

Work Order ID 73444

Thursday, September 01, 2011 7:28:57 AM



Page 1

Item ID: D3546-1

Accept



Setup Start



Revision ID:

Item Name: Clip

Stop



Start Date: 8/31/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/09/01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3546	Rev A	

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 . 05C

Memo

1-Cut as per Dwg D3546

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B1-L9-19

30

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B11-L9-19

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

0.00

5 ulor/20

Counter
430

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130

Operation
Description

NC BRAKE

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

Brake NC

Memo

Form as per Dwg D3546

SB 1109129

30

140



QC5- Inspect part completeness to step on W/O

0.00

5 1107121

QC

Quality Control

counts
(+30)

150

Identify as per dwg & Stock Location: 240

0.00

Packaging

Packaging

Memo

0.00

1107129 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/10/348
MF
11-09-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 7:28:54 AM

Page 1

Work Order ID: 73444



Parent Item: D3546-1



Parent Item Name: Clip

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-09-27 JLM
remove finish DD 10.03.29 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 		Purchased	No			100	sf	221.1550	0.04	0.421053	1.5		

304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT020	70.655	
113062	6.155	
116979	64.5	
MAT021	150.5	
118217	150.5	118217

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	J3444
Description: Clip	Part Number:	D3546-1
Inspection Dwg: D3546	Rev: A	Page 1 of 1

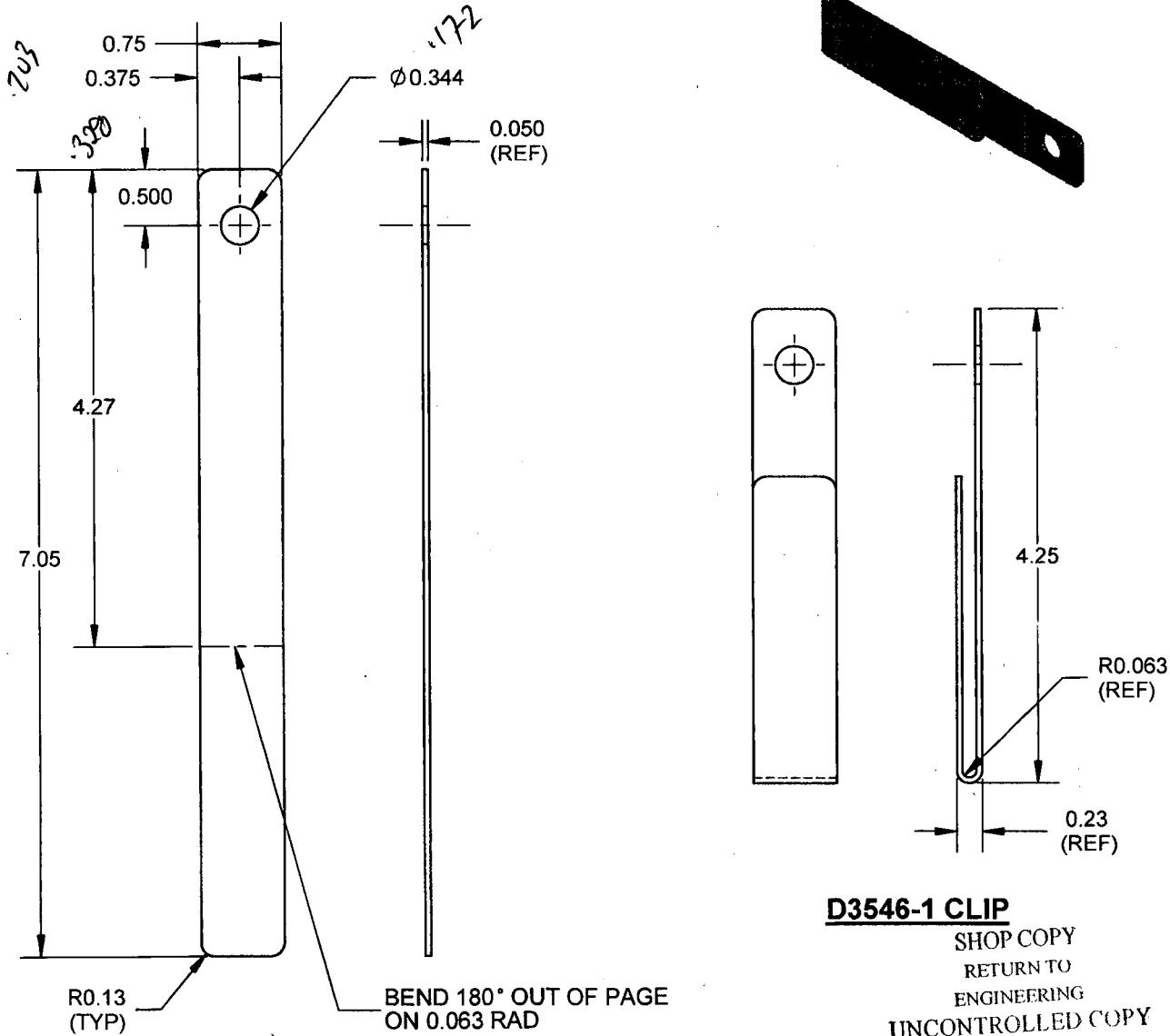
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: FB	Audited by: S	Prototype Approval: N/A
Date: 11-9-19	Date: 11/09/20	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>GP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3546	REV. A	SHEET 1 OF 1
DATE 06.09.15		TITLE CLIP	SCALE 1:1	
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE		



D3546-1F FLAT PATTERN

D3546-1 CLIP

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 7344

CL1109101

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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